

ASAP

Date: Friday, 23/11/2007 7:43:03 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING ANGLE		
Job Number	: 35968					
Estimate Number	: 10412					
P.O. Number	: N/A		Part Number	: D2416		
This Issue	: 23/11/2007 S.O. No. : N/A		Drawing Number	: D2416 REV. B		
Prsh Rev.	: NC		Project Number	: N/A		
First Issue	: MA		Drawing Revision	: B		
Previous Run	: 26907		Material	: N/A		
Written By			Due Date	: 30/11/2007 Qty: 20 Um: Each		
Checked & Approved By						
Comment	: Est:C 03.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet   <b>Comment:</b> Qty.: 0.0255 sf(s)/Unit Total : 0.5103 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Identify for D2416 <i>BS 07-11-26</i>
2.0	WATER JET	FLOW WATER JET   <b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D2416 Dwg Rev: <i>B</i> <i>BS 07-11-26</i> Prog Rev: <i>B</i> <i>(20)</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE   <i>BS 07-11-26</i> <b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK   <b>Comment:</b> SECOND CHECK <i>(20)</i> <i>locally</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1   <b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack <i>07/11/26 (20)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/11/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/11/2007 7:43:03 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 35968

Part Number: D2416

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D2416

83 07/11/27 (20)

7.0 QC5 INSPECT WORK TO CURRENT STEP



coated  
7/11/27 (20)

Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HJ 07-11-28 (20)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

BK 07-11-28 (20)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST32

AS 07/11/28 (20)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/28 (20)

Job Completion



u 07/11/29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

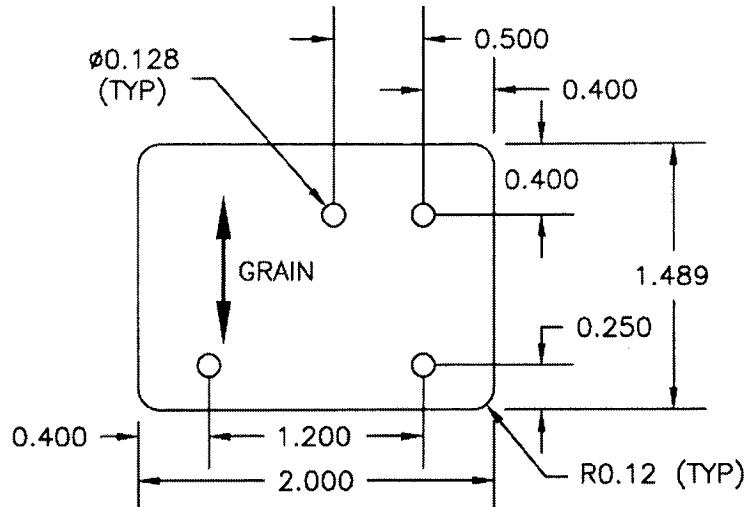
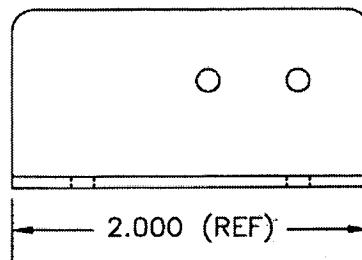
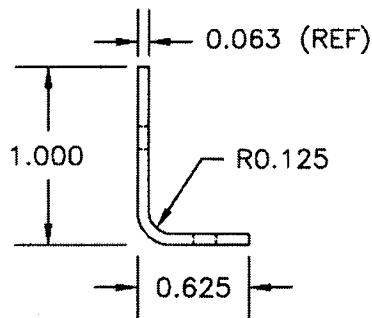
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>RF</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2416
DATE 03.04.09		REV. B SHEET 1 OF 1
		TITLE MOUNTING ANGLE
		SCALE 1:1
A	95.04.06	NEW ISSUE
B	03.04.09	ADDED Ø0.128 & FLAT PATTERN

RELEASED  
03.05.07**FLAT PATTERN****BEND DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3/T3511 0.063" THICK PER QQ-A-250/4 (REF DART SPEC: M2024T3S.063)
- 2) FINISH: ACID ETCH AND ALODINE AS PER DART QSI 005 4.1
- 3) DEBURR ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

DART AEROSPACE LTD	Work Order:	35968
Description: MOUNTING ANGLE	Part Number:	D2416
Inspection Dwg: D2416 Rev: B		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## First Article      Prototype

Measured by:	LB	Audited by:	S	Prototype Approval:	✓
Date:	07-11-26	Date:	07/11/26	Date:	07/11

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	